

Date: Thursday, 02/04/2009 2:25:09 PM
User: Julie Dawson

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	JACK SADDLE
Job Number	46831		
Estimate Number	11177		
P.O. Number	:	Part Number	D2281
This Issue	02/04/2009	Drawing Number	D2281 REV G
Prsht Rev.	NC	Project Number	N/A
First Issue	/ /	Drawing Revision	G
Previous Run	45383	Material	:
Written By	:	Due Date	20/04/2009
Checked & Approved By	JLD 09.04.02		
Comment	Est Rev:A	Removed from 9 Digit	05-12-02 JLM
	Est: rev B	06.07.17	waterjetEC
Additional Product			
Job Number:			
Seq. #:	Machine Or Operation:	Description :	
1.0	M304S14GA	304SS sheet .080	
Comment: Qty.: 0.1313 sf(s)/Unit Total : 13.1250 sf(s) 304SS .080 batch: 110 993 13 9-4-23			
2.0	WATER JET	FLOW WATER JET	
Comment: FLOW WATER JET 1-Cut as per Dwg D2281 Dwg Rev: G Prog Rev: G 13 9-4-23			
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
Comment: INSPECT PARTS AS THEY COME OFF MACHINE 13 9-4-23			
4.0	QC8	SECOND CHECK	
Comment: SECOND CHECK S 02/04/24 X/10			
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
Comment: Deburr N/A S			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 02/04/2009 2:25:09 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: JACK SADDLE

Job Number: 46831

Part Number: D2281

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 BRAKE NC

NC BRAKE



Comment: NC BRAKE

Form as per D2281 using D2281-T2

SB 09/04/29 (110)

7.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

3 09/04/29 (X110) counts

8.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: _____

ST 261

AS 09/05/01 (X110)

9.0 QC21

FINAL INSPECTION/W/O RELEASE



09/05/01 (X110)

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF
09 05 - 01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	<u>46831</u>
Description: Jack Saddle	Part Number:	D2281
Inspection Dwg: D2281 Rev: G		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

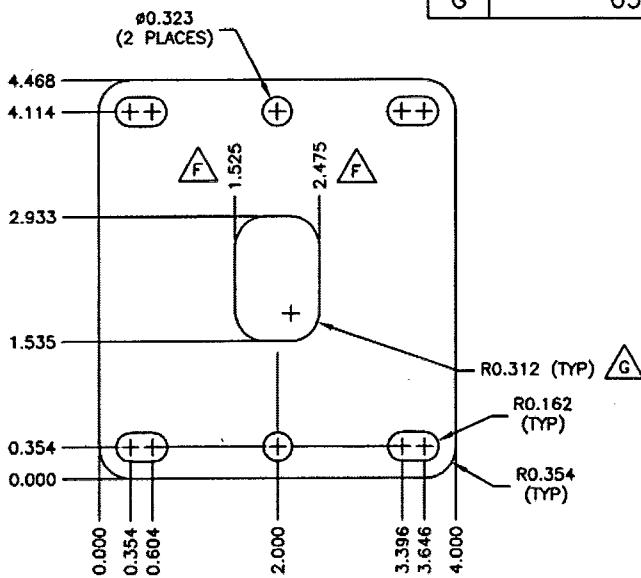
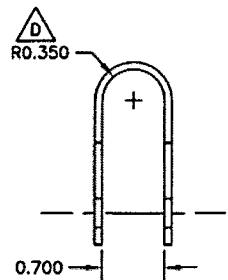
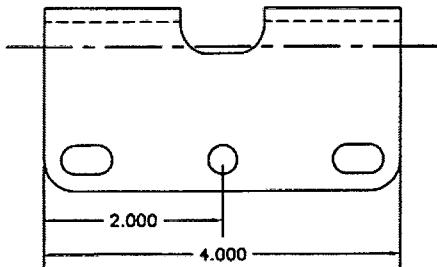
Measured by: <u>AB</u>	Audited by: <u> </u>	Prototype Approval: N/A
Date: <u>9-4-23</u>	Date: <u>07/04/24</u>	Date: N/A

Rev	Date	Change	Revised by	Approved
A	06.09.08	New Issue	KJ/JLM	<i>[Signature]</i>

DART

DESIGN BW	DRAWN BY <i>IP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>IP</i>	APPROVED <i>MRS</i>	DRAWING NO. D2281 REV. C SHEET 1 OF 1
DATE 05.06.07		TITLE JACK SADDLE SCALE 1:2
A	94.10.14	NEW ISSUE
B	94.10.18	DIMENSION WAS 2.878
C	94.11.04	ADD TOOLING NOTCH
D	98.03.27	R0.350 WAS R0.280
E	04.11.18	REMOVE TOOLING NOTCHES
F	05.03.16	REDESIGN FLAT PATTERN
G	05.06.07	REDESIGN FLAT PATTERN

RELEASED
IP
05/08/11

FLAT LAYOUT

SHOP COPY

RETURN TO

ENGINEERING

UNCONTROLLED COPY
SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK CENTER

NO. 16831D2281 JACK SADDLE

- 1) MATERIAL: 304/316 SS, 0.080 THICK (REF DART SPEC. M304S14GA)
- 2) FINISH: NONE
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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